

Jan, 2
Work Order ID 77581

Tuesday, December 13, 2011 2:42:11 PM

77581

Page 1

Item ID: D3779-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 12/13/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/5/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: P

Date: 1/12/13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3779

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3779

6061-000

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

BA-1-2

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

BA-1-2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 77581

77581

Page 2

Tuesday, December 13, 2011 2:42:11 PM

Item ID: D3779-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plate
Start Date: 12/13/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/5/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|---------------------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | 8 12/01/02 | | (4) | | | |
| 130 *130* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | M/12/01/02 12-01-02 | | 4 | | | |
| 140 *140* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 4 | 4 | 12/01/02 | |

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NOTE: Date & initial all entries

77581

Tuesday, December 13, 2011 2:42:11 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/13/2011 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/5/2012 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Identify as per dwg & Stock Location: STM

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

4X SD 12-01-03

CK 12/01/04

12-01-31
(H)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 13, 2011 2:42:15 PM

Page 1

Work Order ID: 77581

77581

Parent Item: D3779-3

D3779-3

Parent Item Name: Plate

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.050 | | Purchased | No | | | 100 | sf | 129.8600 | 0.1937 | 0.815579 | | | |

M6061T6S 050

6061-T6 .050 Sheet

**

BD-1-2

Location

Loc Qty

Loc Code

MAT021

129.86

113216

16

114799

94.86

114993

19

114799

(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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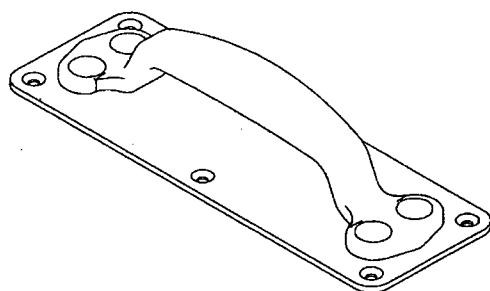
NOTE: Date & initial all entries

| QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION |
|--------------|--------------|---------------|-----------------|
| X | | D3779-041 | HANDLE ASSEMBLY |
| | X | D3779-043 | HANDLE ASSEMBLY |
| 1 | 1 | D3203-1 | HANDLE |
| 1 | | D3779-1 | PLATE |
| | 1 | D3779-5 | PLATE |
| 4 | 4 | MS20426AD10-9 | RIVET, CSK |

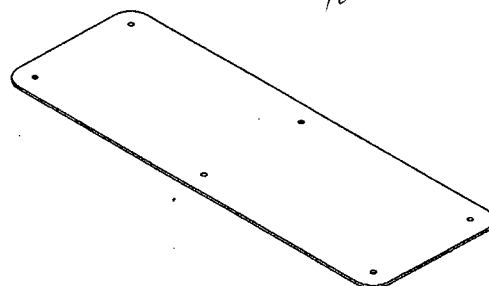
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHIN THE
WORK ORDER
NO. 77581

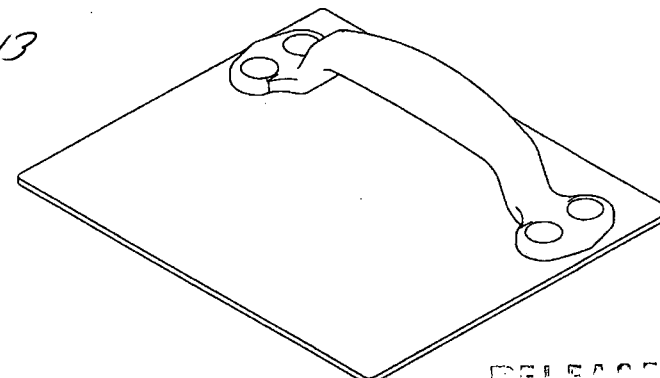
01/12-13



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-3 DOUBLER PLATE



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

RELEASED
2011-12-01

| | | | |
|------------|--|--|--------------|
| B | REFORMAT IAW DART QSI 043: MS20426AD10-9 WAS MS20426AD10-8 (ZN D6-1, B8/B4-2). REASON: PRODUCTION FACILITY (PAR11-138). | MB | 11.11.24 |
| A | NEW ISSUE | AJS | 08.04.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. | REV. B |
| CHECKED | | D3779 | SHEET 1 OF 4 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
| DE APPR. | | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 11.11.24 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

C

B

B

D3779-1
PLATED3779-5
PLATED3203-1
HANDLE

MS20426AD10-9
RIVET, CSK BOTH ENDS
4 PL

D3203-1
HANDLE

MS20426AD10-9
RIVET, CSK BOTH ENDS
4 PL

D3779-041 HANDLE ASSEMBLY
(EXTERIOR) 6.8



D3779-043 HANDLE ASSEMBLY
(INTERIOR) 7.9

RELEASED
2011-12-01

77581

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

| | | | |
|--|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. | | D3779 | SHEET 2 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
| DATE | 11.11.24 | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |
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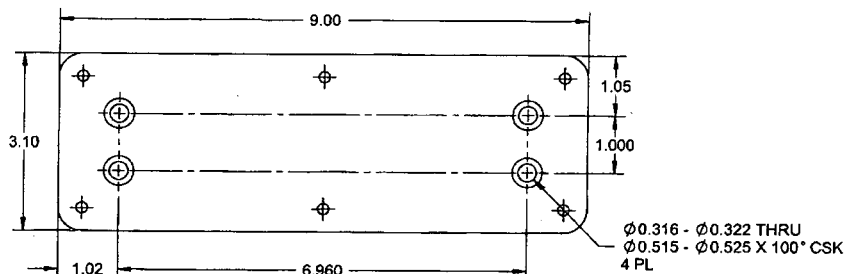
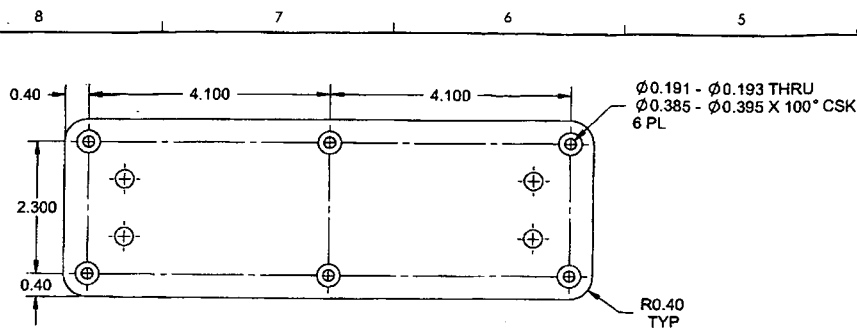
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

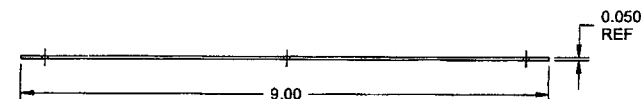
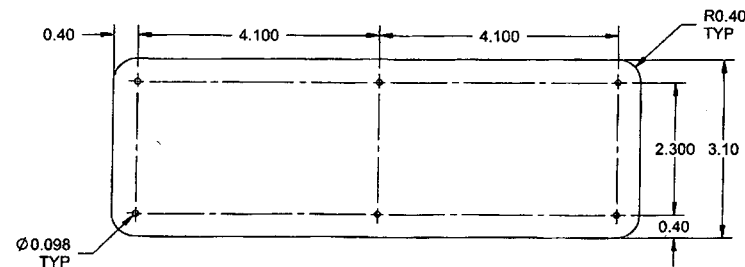
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3779-1 PLATE



D3779-3 PLATE

NOTES:

1) MATERIAL: -1 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED






5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY D3779-3 WITH DART P/N "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
(DO NOT IDENTIFY D3779-1)

7) WEIGHT: 0.14 lbs FOR -3

71581

RELEASED
2011-12-01

| | | | |
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| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3779 | SHEET 3 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Ø 0.316 - Ø 0.322 THRU
Ø 0.515 - Ø 0.525 X 100° CSK
TYP

R0.13
TYP

8.60

7.31

1.000

1.30

0.82

6.960

D3779-5 PLATE

0.125
REF

77581

RELEASED
2011-12-01

NOTES:

1) MATERIAL: -5 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3779 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HANDLE ASSEMBLY, CABIN SLIDING DOOR | NTS |
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